

Work Order ID 145995

145995

Page 1

Tuesday, May 10, 2016 10:40:57 AM

Item ID: D206-811-017 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 L1/L3/L4 Replacement Engine Mount
 Start Date: 4/29/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-811-3	B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-811-017 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.12							
Quality Control									

MCS 16-05-12

MAY 10 2016

DAS
6
9-89

DAS
27
9-89

MAY 16 2016

3x
MAY 10 2016

DAS
6
9-89

DAS
28
9-89

3x
MAY 16 2016

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

Work Order ID 145995

Tuesday, May 10, 2016 10:40:57 AM

145995

Page 2

Item ID: D206-811-017

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 L1/L3/L4 Replacement Engine Mount

Start Date: 4/29/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-811-017

Location: _____

PPP Rev: _____

fig 019

0.00

0.00

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.40

31

27
9-89
MAY 16 2016

MCS

MAY 17 2016

MCS

MAY 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Tuesday, May 10, 2016 10:40:56 AM

Page 1

Work Order ID: 145995

145995

Parent Item: D206-811-017

D206-811-017

Parent Item Name: 206 L1/L3/L4 Replacement Engine Mount

Start Date: 4/29/2016

Required Date: 5/5/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.19 AS PER IIN REV.B DD VERF:JLM IPP REV:C
14.07.07 per chg002/ECN14-584 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4834-041		Manufactured	No				Each	4.0000	1	43			
D4834-041 206L MID Leg Assembly, LH													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST230B

4

116517

2

132944

2

Each

6.0000

**

DAS
28
9-89

D4834-042		Manufactured	No				Each	6.0000	1	13			
D4834-042 206L MID Leg Assembly, RH													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST230B

6

116518

2

121412

4

Each

7.0000

**

DAS
28
9-89

D4835-041		Manufactured	No				Each	7.0000	2	86			
D4835-041 206L FWD Leg Assembly													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST230B

7

116521

4

121706

2

122438

1

DAS
28
9-89

MAY 10 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____						

Picklist Print

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Page 2

Work Order ID: 145995

145995

Parent Item: D206-811-017

D206-811-017

Parent Item Name: 206 L1/L3/L4 Replacement Engine Mount

Start Date: 4/29/2016

Required Date: 5/5/2016

Start Qty: 4.00

Required Qty: 4.00

D4836-041

Manufactured No

Each 4.0000

D4836-041

206L AFT Leg Assembly, LH

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST230B

4

116523
121529

2
2

2
1
2

D4837-041

Manufactured No

Each 6.0000

D4837-041

206L AFT Leg Assembly, RH

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST230B

6

116525
121640

2
4

2
1

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

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Table 2. – Fastener Torque

Fastener Type	Torque (in-lbs)	Torque (N*m)
1/4-28  1	25-35	2.8-4.0
1/4-28  2	50-70	5.7-7.9
3/8-24  3	70-90	7.9-10.2
3/8-24  4	85-110	9.6-12.4

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the D206-811-017 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-811-017 REPLACEMENT ENGINE MOUNT KIT <i>(206L-1/L-3/L-4 Models)</i>	0.4 lb 0.18 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	165.5 in 4.20 m	66 in-lb 0.8 m-kg

5.0 PARTS LIST

Qty -017	Part Number	Description
X	D206-811-017	REPLACEMENT ENGINE MOUNT KIT <i>(206L-1/L-3/L-4 Models)</i>
1	D4834-041	MID LEG ASSEMBLY, LH
1	D4834-042	MID LEG ASSEMBLY, RH
2	D4835-041	FWD LEG ASSEMBLY
1	D4836-041	AFT LEG ASSEMBLY, LH
1	D4837-041	AFT LEG ASSEMBLY, RH